

Date: Friday, 14/11/2008 10:20:57 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SKID TUBE ASSEMBLY
Job Number : 43443	
Estimate Number : 10023	
P.O. Number :	Part Number : D205634041
This Issue : 14/11/2008 S.O. No. :	Drawing Number : D2580 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SKIDTUBES	Drawing Revision : D
Previous Run : 43442	Material :
Written By :	Due Date : 28/11/2008 Qty: 1 Um: Each
Checked & Approved By : <u>JUD 08.11.14</u>	
Comment : Est Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ	
Est Rev: O 06.02.28 Added paperwork EC	
Est Rev:P 07-07-09 SS Wearplates & Gaskets JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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JUD 09-01-07

**Comment:** DOCUMENT CONTROL

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

504/01/07

2.0	D25001190	Ext'n -I' Beam Tube 4"
-----	-----------	------------------------

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2500-1-190	Skid Tube Extrusion	<u>6-37544</u>

D/MB 08-11-17

3.0	D2596	Web, 205 Skidtube
-----	-------	-------------------

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2596	205 Web	<u>43374</u>

JUD 8-12-4

4.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
-----	-------------	-----------------------

**Comment:** LANDING GEAR RESOURCE 1

1- Inspect mat'l D2500-1-190 for damage

2-Cut D2500-1-190 per Dwg D2580 if necessary Deburrr ends

3-Acid etch and Alodine tube per QSI 005 4.1

D/MB 08-11-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 43443

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

S 08/12/4

6.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes using drill jig DT 8149(Do not use cutting fluid)

2-Open holes to 0.500" as per Dwg D2580without cutting fluid

3-Countersink holes as per Dwg D2580without cutting fluid

4-Deburr and blow out all chips from inside of tube

5-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

Pick:

Qty Part Number Description Batch

A/R Sikaflex-291 M109883

Sikaflex expire date: 9-7-11

Start Time: 1:30 Date: 8-12-4

Fin Time: 2:00 Date: 8-12-09

JD 8-12-4

7.0

BENDING

BENDING MACHINE - SKIDTUBES



Comment: BENDING MACHINE

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

ST 08-12-09

8.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr ends

2-Prepare tube for welding, remove alodine as required.

2 BE
pm 08-12-09 (D)

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 43443

Part Number: D205634041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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9.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

BE 08/12/12

10.0	D25763	Step (maching detail)
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2576-3	Step	<i>B30392</i>

BE 08/12/12

11.0	D2579	Crossbolt Spacer
------	-------	------------------



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
20	D2579	Spacers	<i>B41666</i>

Pm' 08/12/09

AK

12.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
------	-------------	-----------------------



Comment: LARGE FABRICATION RESOURCE 1

2-Weld step D2576 as per Dwg. D2580 and QSI 004.

A/R Aluminum Rod

m109560

BE 08/12/12

3-Weld crossbolt spacers D2579 as per Dwg. D2580 and QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R Aluminum Rod

m109560

BE 08/12/12

4-Grind welds as per Dwg D2580 Grind flush ridge made from bending

5-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web. Deburr

6-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes

7-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Deburr

8-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

BE
Pm'
08-12-12

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 43443

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description:

13.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 08/12/22 (X)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/12/22 (X)

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Pressure wash as per QSI 005

M-L 08/12/22 (1X)

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

11:20
320 OF
11:50

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

M-L 08/12/22 (1X)

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/12/22 (1)

18.0

D2855

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Cap

Batch:

B42343

FL

19.0

AN35A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

Batch:

M100188

FL 08/12/22 (1)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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Job Number: 43443

Part Number: D205634041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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20.0	AN960JD10L	Washer
------	------------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
Washer
Batch: M105793

FL

21.0	ALS71032130	Insert
------	-------------	--------



Comment: Qty.: 50.0000 Each(s)/Unit Total: 50.0000 Each(s)
Insert
Batch: M105819

FL

22.0	AN3C4A	BOLT
------	--------	------



Comment: Qty.: 50.0000 Each(s)/Unit Total: 50.0000 Each(s)
BOLT
Batch: M110139

FL

23.0	AN960C10L	washer
------	-----------	--------



Comment: Qty.: 50.0000 Each(s)/Unit Total: 50.0000 Each(s)
washer
Batch: M109798

FL

24.0	D356613	Gasket
------	---------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
GASKET
Batch: B42147

FL

25.0	D35665	Gasket
------	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
GASKET
Batch: B43710

FL

26.0	D35661	Gasket
------	--------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
GASKET
Batch: B43709

FL 08/12/22

①

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

D356413

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B42257

FL

28.0

D356411

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B43707

FL

29.0

D35649

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B42258

FL

30.0

D35645

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B43408

FL

31.0

D25943

O-Ring, 205 Skidtube



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

O-Ring

Batch: B29908

FL

32.0

D25941

Plug, 205 Skidtube



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Plug

Batch: B43884

FL

33.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R

Sikaflex-291

M109883

FL 08/12/22

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

Sikaflex expire date: 09/11

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R Sikaflex-291

Sikaflex expire date: 09/07

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch: M109219

34.0

QC5

INSPECT WORK TO CURRENT STEP



m 08 12 23



(1)

Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

35.0

PACKAGING 1

PACKAGING RESOURCE #1



(X) SP

Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-634-041

Location: 13

PPP Rev: 1

9/1/2

36.0

QC21

FINAL INSPECTION/W/O RELEASE



(1)

Comment: FINAL INSPECTION/W/O RELEASE

HD 09/01/07

MF 09-01-07

Job Completion



43443

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN #	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07-06-28 #

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL $\varnothing 0.297$ HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

SHOP COPY
RETURN TO
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WITHOUT NOTICE
WORK ORDER
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RELEASED
07-06-28

Diagram illustrating the grinding locations for the D2576-3 step. The diagram shows a cross-section of the step with the following labels:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- GRIND FLUSH
- LOCATION RIDGE ON UNDERSIDE OF D2576
- $\frac{1}{4}$

Technical drawing of a circular component with a central hole and a rectangular slot. The drawing includes dimension lines and labels for various parts and dimensions:

- DRILL PRIOR TO D2855 CAP INSTALLATION (2 PLACES)
- SEAL WITH SIKAFLEX-241/-291
- AN3-5A BOLT (1)
- AN960JD10L WASHER (1)
- (2 PLACES)
- D2855 CAP
- 0.40

5

D2579 SPACER

D2596 WEB (REF)

ALS7-1032-130 (REF)
(TYP 50 PLACES)

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

Diagram showing the elevation view of the D2596 web. Key dimensions and features include:

- Distance to aft end of D2596 web: 37.50
- Dimensions 3 and 7 (triangles) indicating specific points or sections.
- Dimensions 1.750 and 1.750 (horizontal distances between vertical lines).
- Dimension 8.750 (horizontal distance from the left edge to the first vertical line).
- Dimension 17.375 (horizontal distance from the left edge to the second vertical line).
- Dimension 26.000 (horizontal distance from the left edge to the third vertical line).
- Dimension 34.188 (horizontal distance from the left edge to the fourth vertical line).
- Dimension 57.313 (REF) 7 EQUAL SPACES 8.188 PITCH (horizontal distance from the left edge to the seventh vertical line).
- Dimension 91.500 (horizontal distance from the left edge to the eighth vertical line).
- Dimension 190.0 (D2500-1) (total horizontal distance).
- Dimension 38.0 (horizontal distance from the left edge to the first vertical line).
- Dimension 0.508 (TYP.) (40 PLACES) (vertical distance from the centerline to the top/bottom edges).
- Reference to Detail A (indicated by arrows pointing to the first and eighth vertical lines).

Technical drawing of a road cross-section showing a 4% grade and a 20.0m curve radius. The drawing includes dimensions for the distance between the hole and the tangent point (1.0m), the distance between the hole and the tangent point (13.4m), and the distance between the hole and the tangent point (32.0 ± 1.0m). The drawing also shows a 1.4m offset and a 11.0m offset.

0.5

1.5

1.5

D

P P P P P P P

8

1.5

1.5

WELD AS PER DETAIL B

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

REFER TO DETAIL C

D3566-1

D3566-5

D3566-1

D3566-1

D3564-11

D3564-5

D3564-9

D3564-1






AN3C4A BOLT (1)

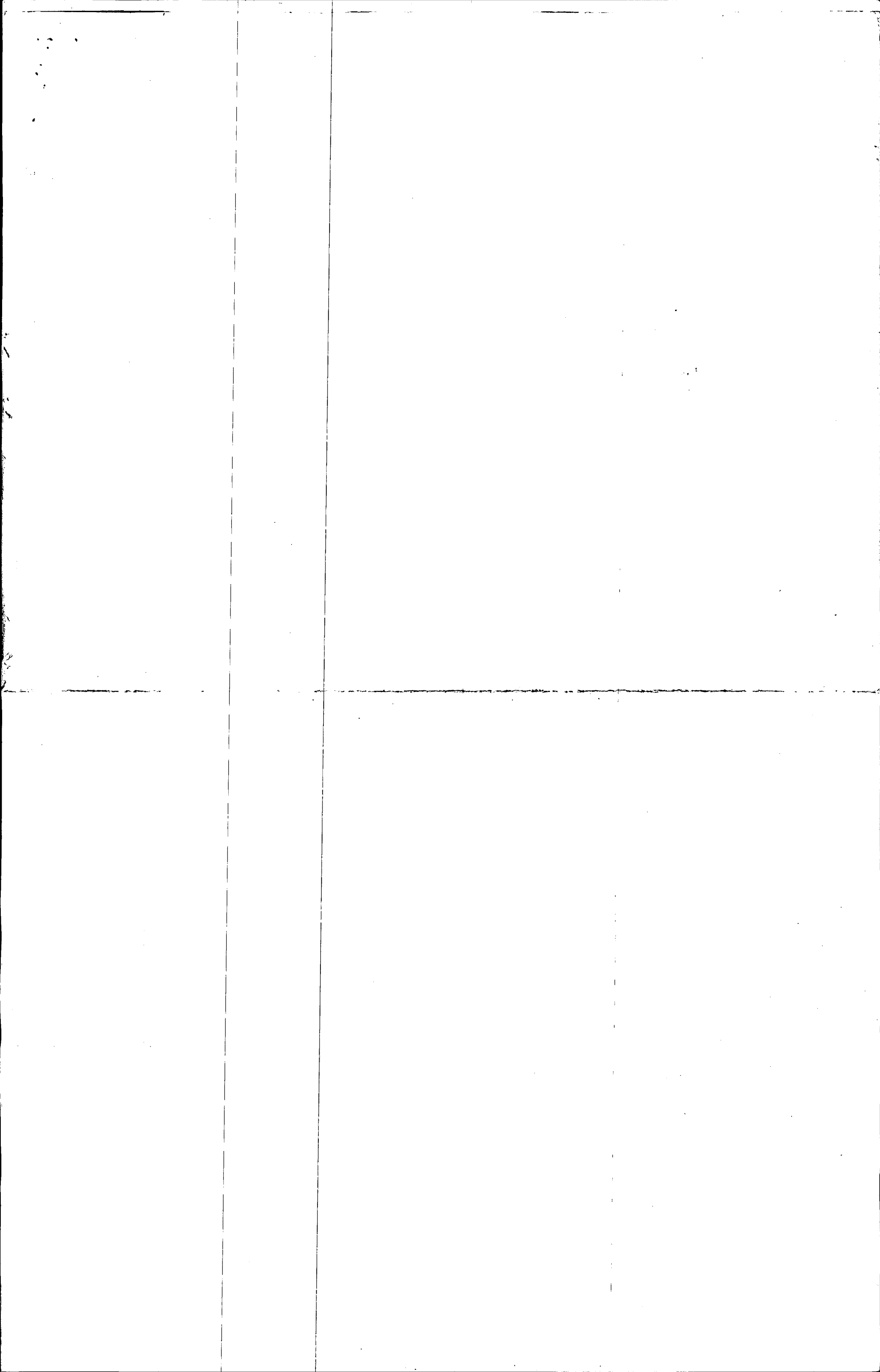
AN960C10L WASHER (1)

(50 PLACES)

DESIGN	JJ	DRAWN BY	
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13 SHOP COPY
RETURN TO
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WITHOUT NOTICE
WORK ORDER
13 NO. 43443

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	CHECKED 	APPROVED 	DRAWING NO. D2580	REV. SHEET 2 OF
	DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE 1:



NO. 182

**AWS D17.1.2001
QUALIFICATION TEST RECORD**

Name: Barclay Elliot
Job number: B43240 A
Part number: 1205 68 041
Description: 205 Skid tube
Welding Process: Tig[☒] Mig[☐]
Base material: Alum.
Current: AC[☒] DC[☐]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[☐]
Penetration: pass[☒] fail[☐]

UNACCEPTABLE

Cracks: pass[☒] fail[☐]
Undercut: pass[☒] fail[☐]
Pin holes: pass[☒] fail[☐]
Overlap (cold lap): pass[☒] fail[☐]
Porosity (surface): pass[☒] fail[☐]
Coloration: pass[☒] fail[☐]

Qualifier David Dewal Date of Test Coupon 08/11/20
Welder Barclay Elliot Date of Test Coupon 08/11/20

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date: Thursday, 23/10/2008 1:25:43 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 205 SKID INSTALLATION KIT
Job Number : 42901	
Estimate Number : 12519	
P.O. Number :	Part Number : D205634015
This Issue : 23/10/2008 S.O. No. :	Drawing Number : IIN D205-634 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : 11 Type : SKIDTUBES	Drawing Revision : D
Previous Run : 42900	Material :
Written By :	Due Date : 01/02/2009 Qty: 1 Um: Each
Checked & Approved By : <u>JW 08.10.23</u>	
Comment : Est Rev:A New Issue 00-04-04 EC Est Rev:B 08-08-12 now @ chg 005 (DSI 9417) DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL
Comment: Photocopy D205-634 bluefile & type labels per PPP D205-634-015 CHG 005 <u>8 09/01/07</u>		
2.0	42901A	SKID TUBE ASSEMBLY
Comment: Sub-Component SKID TUBE ASSEMBLY 1 x D205-634-045 Batch <u>42901A</u>		
3.0	K10003	Saddle, D205-634-011
Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) D205-634-011 Saddle Kit <u>By 3824</u> <u>9.01/07</u> (1)		
4.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
Comment: INSPECT 100% KITS FOR COMPLETENESS <u>5 09/01/07</u> (40)		
5.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and pack for shipping as per PPP D205-634-015 Location: <u>N</u> PPP Rev: <u>N</u>		

42901A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 SKID INSTALLATION KIT

Job Number: 42901

Part Number: D205634015

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

D 09/01/07
MF 09-01-07

Job Completion



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 23/10/2008 3:30:57 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 205 SKID INSTALLATION KIT
Job Number	: 42901		
Estimate Number	: 12519		
P.O. Number	:	Part Number	: D205634015
This Issue	: 23/10/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: IIN D205-634 REV D
First Issue	: 23/10/2008	Project Number	: N/A
Previous Run	: 42900	Drawing Revision	: D
	Type : SKIDTUBES	Material	:
Written By	:	Due Date	: 01/02/2009
Checked & Approved By	:	Qty:	1 Um: Each
Comment	: Est Rev:A New Issue 00-04-04 EC Est Rev:B 08-08-12 now @ chg 005 (DSI 9417) DD verified by:EC		

REFERENCE ONLY

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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JUD 08-12-03



Comment: Photocopy D205-634 bluefile & type labels per PPP D205-634-015 CHG 005

2.0	42901A	SKID TUBE ASSEMBLY
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Comment: Sub-Component SKID TUBE ASSEMBLY
 1 x D205-634-045 Batch _____

3.0	K10003	Saddle, D205-634-011
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 D205-634-011 Saddle Kit

Job Completion

